

Work Order ID 67950



Page 1

Tuesday, April 05, 2011 7:51:52 AM

Item ID:	D3188-2M	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SPACEPOD BODY RH					
Start Date:	4/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/04/05</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								

100
 PURCHASING 0.00
Purchasing
Purchasing
Memo
Issue P/O: 13797
Description: D3188-2MBODY
SHIP: QTY (8) D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

CL 11/04/05 ①

110
 Receive & Inspect for Damage & Mat'l Certs 0.00
Packaging
Packaging
Memo
Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Puf/6/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67950

Page 2

Tuesday, April 05, 2011 7:51:52 AM

Item ID: D3188-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD BODY RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <i>Composites</i>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

W 11 08 25 (J)

85 11-08-25

11/8/25 J

CY 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 7:51:49 AM

Page 1

Work Order ID: 67950

Parent Item: D3188-2M

Parent Item Name: SPACEPOD BODY RH



Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
 IPP rev B rev D dwg 07.03.07 ec
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213  Insert		Manufactured	No			100	Each	170.0000	8	8			
					<u>Location</u> ST008				<u>Loc Qty</u> 170 170				
					30809					8			
D3188-2P  Spacepod Body		Purchased	No			110	Each	0.0000	1	1			
					67950					1			

CY 11/04/05 (8)

Rev 4/20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

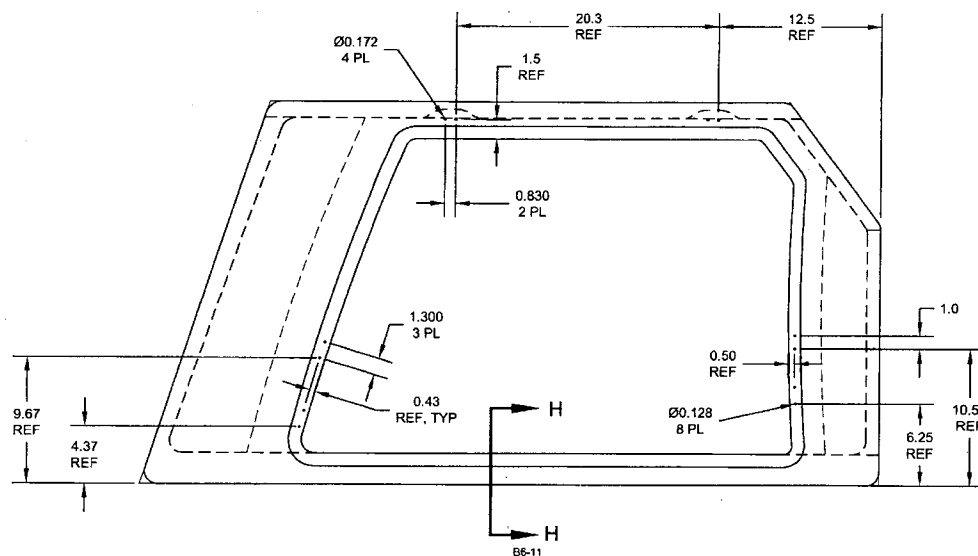
8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

RELEASED
2009-10-20
MP

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
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DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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CL 11/04/05
W10:67950



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

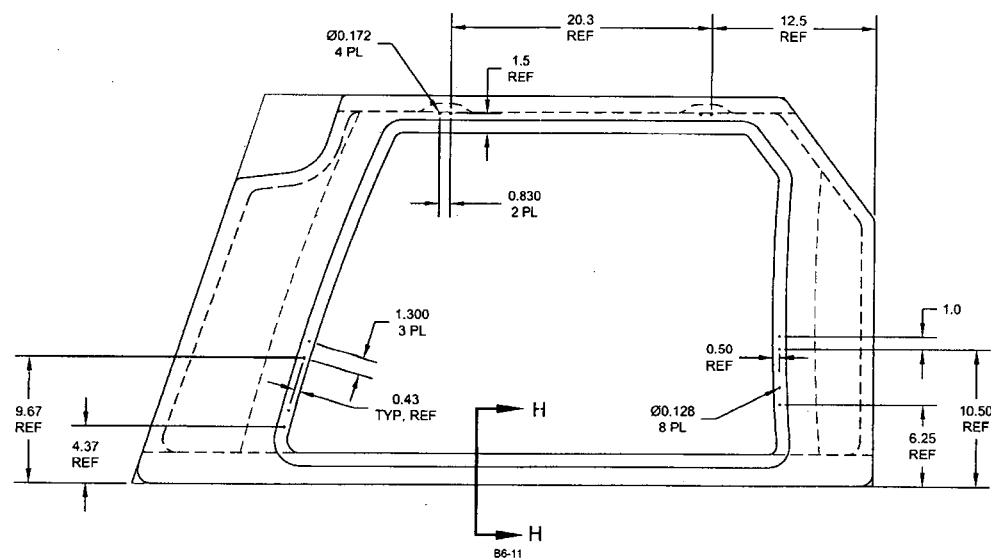
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

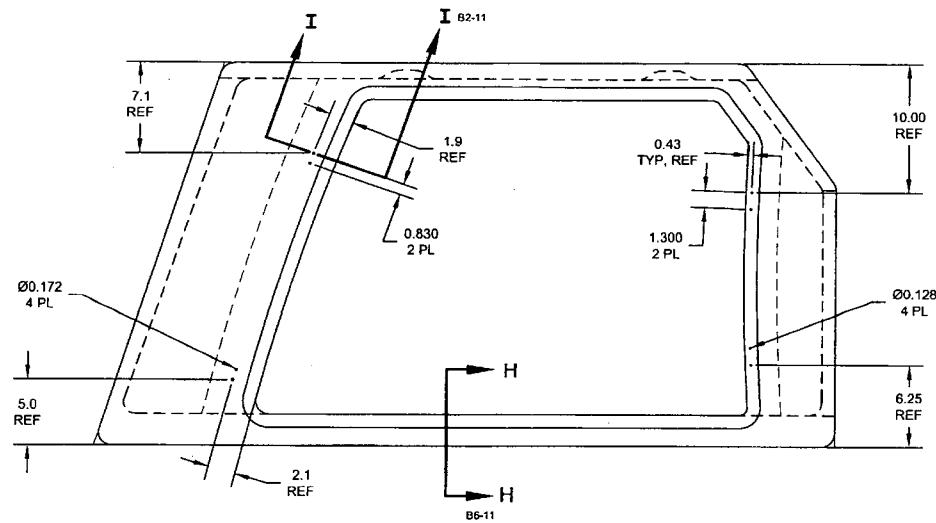
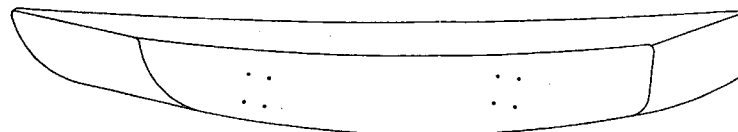
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

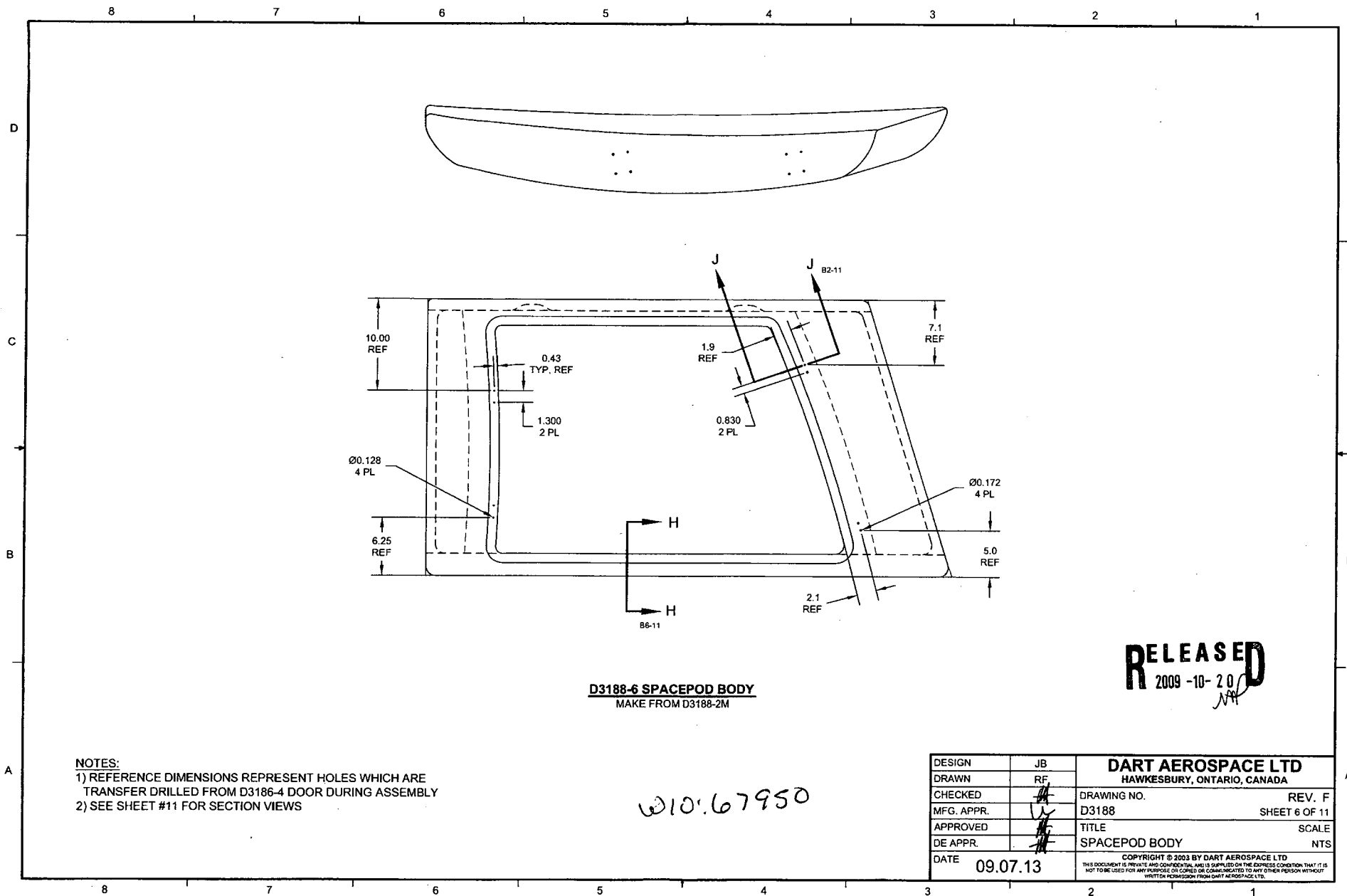
RELEASED
2009-10-20
MD

NOTES:

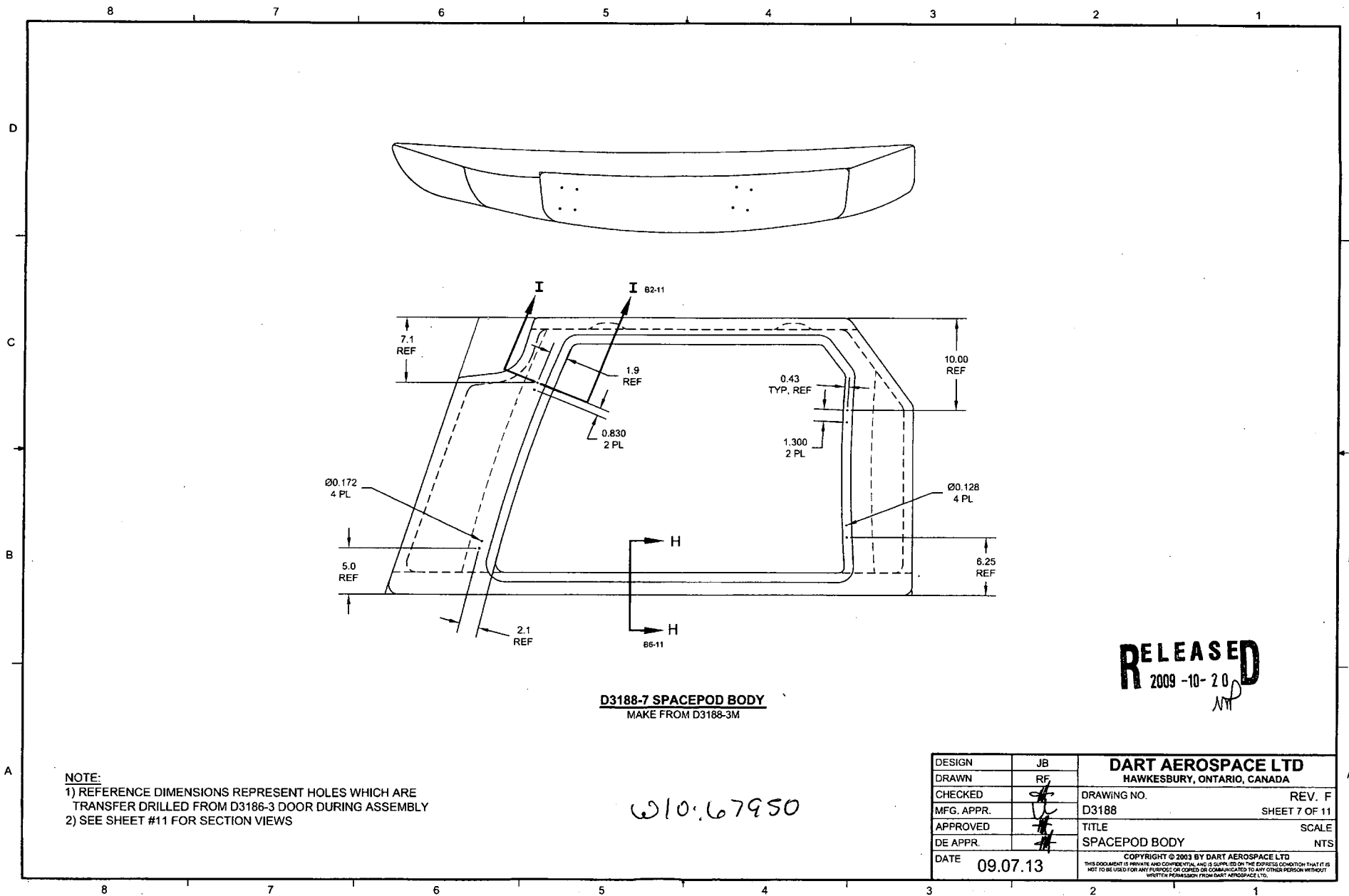
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

W10,67950

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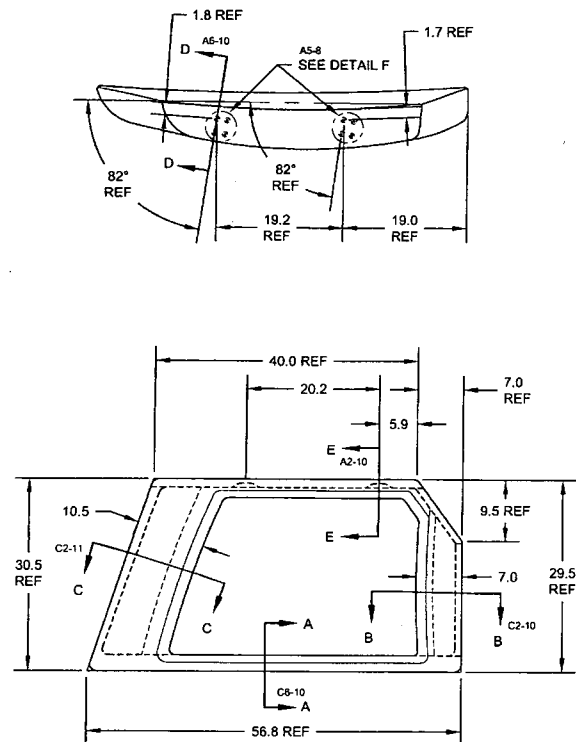
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

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2009-10-20
AM

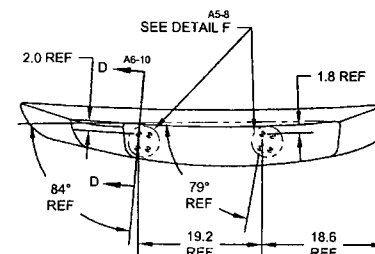
NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

W10.67950

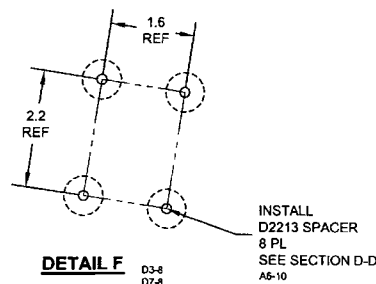
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



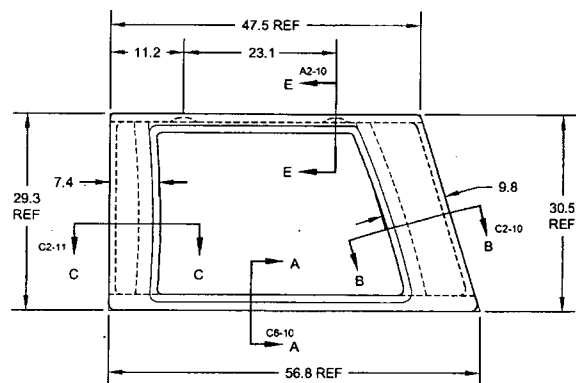
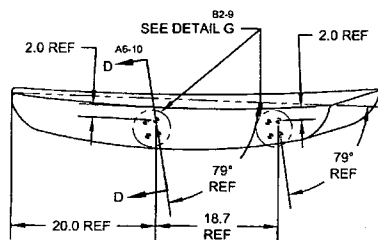
DETAIL F

D3186-1M/-3M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #10 FOR SECTION VIEWS.

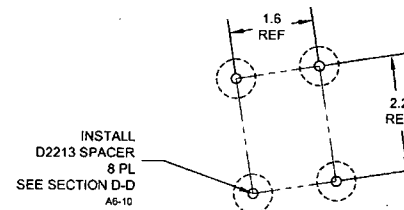
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WID: 67950



D3188-2M SPACEPOD BODY



DETAIL G D6-9

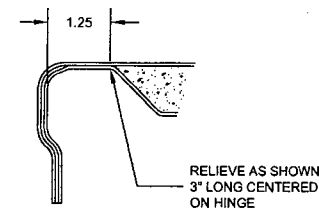
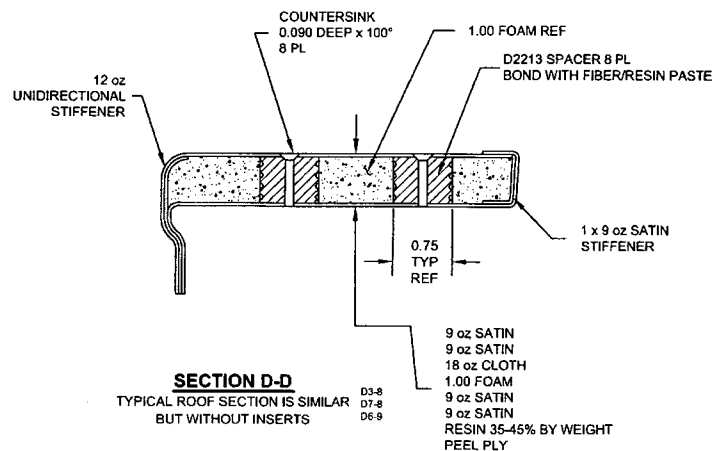
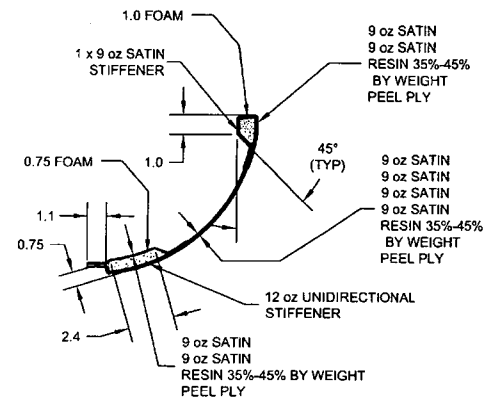
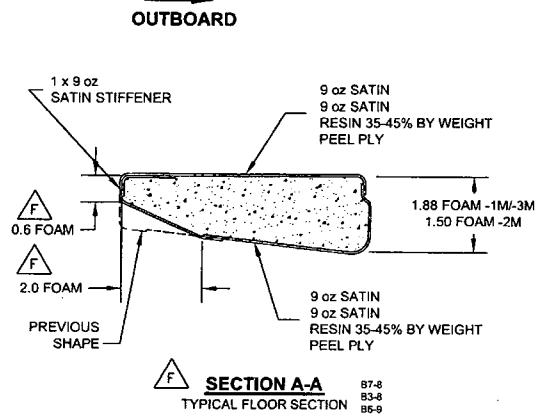
RELEASED
2009-10-20

D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

W10.67950

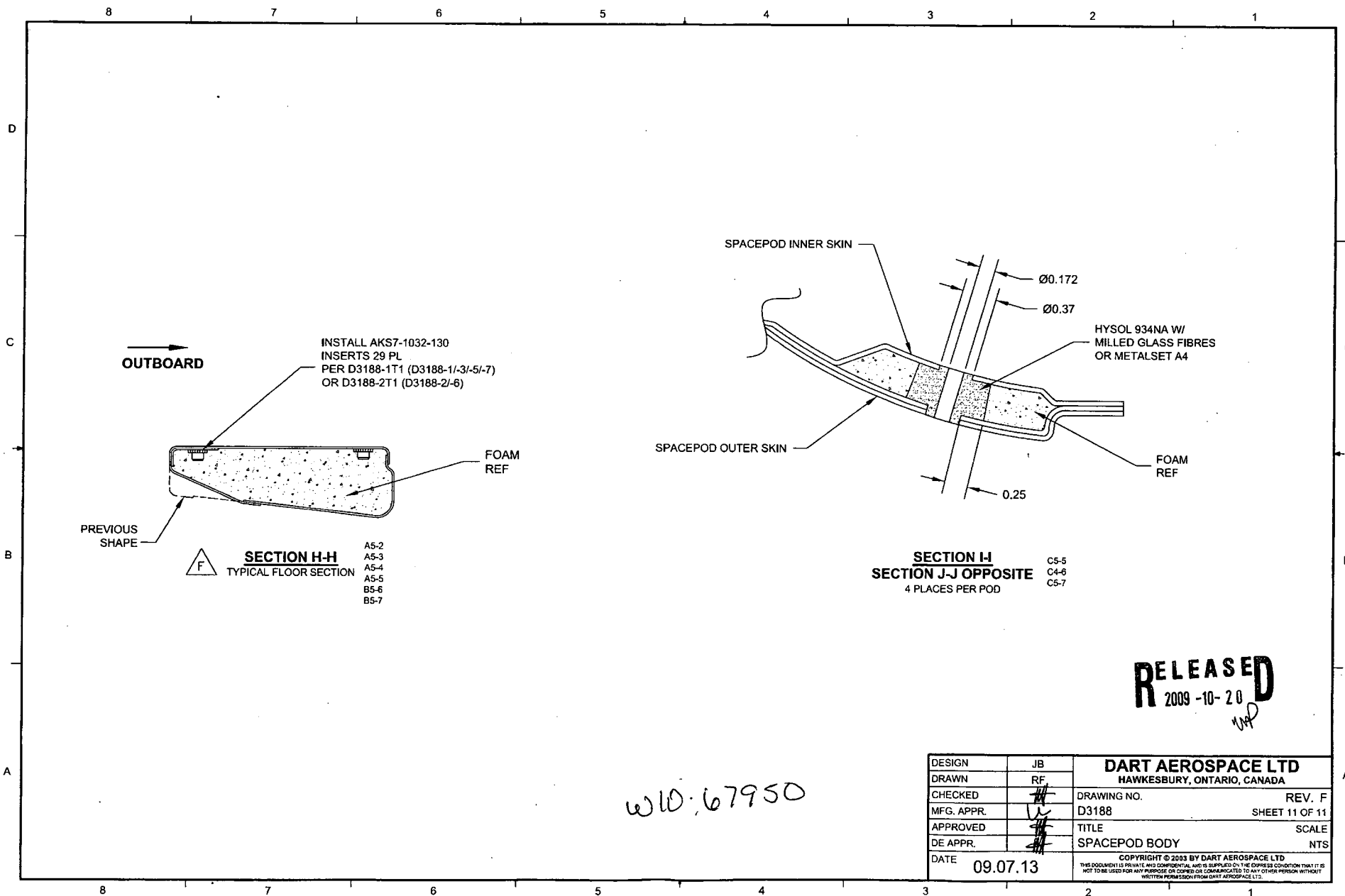
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	U	D3188	SHEET 9 OF 11
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2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	RF	D3188	SHEET 10 OF 11
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W10.67950





Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	38950
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

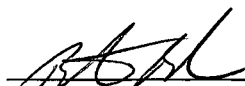
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
16/06/2011	07/04/2011	17271	Chantal Lavoie		PO13797		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0071	Line 2 N° D31882P, Spacepod Body RH B67950 U de M : Each Dwg. D3188 Rév.: F <div><div>No. série</div><div>No. lot</div><div>B67950</div><div>32790</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


Quality department



AQ-357

Date: Mardi, 2011-04-19 07:36:27
Utilisateur: Pascal Carignan

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 32790
Numéro Soumission : 3763
Numéro B.A. :
Cette fois : 2011-04-19 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 32551

Nom Dessin : SPACEPOD BODY RH
Numéro Article : DKC134-0071
Numéro Dessin : D3188
Projet Numéro : DK-362
Révision dessin : F
Matériel : Fibre 7781 et résine 411-350
Date Dûe : 2011-04-26 Qté: 1 Udm: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3188-2



B67950

Process Sheet Rév.: 03 changer le sikkens AAC1390 pour le P15-3
(AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le
Wolo

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: _____

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: _____ Sceau: _____

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0 AC0884 Wighton 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-30234-1

Date: Mardi, 2011-04-19 07:36:27

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 32723

Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

8.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

9.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total: 0.350 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-28778-1

10.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total: 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 29/04/11 Sceau:



12.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0640 GALLON(s)/Unit Total: 0.0640 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 LITRE(s)/Unit Total: 2.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30828-4

14.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0040 GALLON(s)/Unit Total: 0.0040 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7046-1

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 12/05/11 Sceau:



16.0 AMB0355 ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total: 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-26978-2 1-6773-2

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 LITRE(s)/Unit Total: 0.200 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: N/A

Date: Mardi, 2011-04-19 07:36:27

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 32790

Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération:

Description :

18.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0064 GALLON(s)/Unit Total : 0.0064 GALLON(s)

Catalyst N° DDM-9 N° de Lot: N/A

19.0 AAC1611 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)

Polybond B46F N° de Lot: N/A

20.0 TAILLAGE Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 24-5-11 Sceau:



21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30828-4

22.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

23.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 24-5-11 Sceau:



24.0 PERCAGE Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Percer les foam core selon IF134-0020.

Date: 25-5-11 Sceau:



25.0 AAC1611 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)

Polybond B46F N° de Lot: 1-27795-1

Date: Mardi, 2011-04-19 07:36:27

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 32790

Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

26.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Assembler les foam core selon IF134-0020.

Date: 26/05/11 Sceau:



A.M.



27.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-29667-1

28.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 30-5-11 Sceau:



29.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31015-1

30.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

31.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 1/06/11 Sceau:



A.M.

32.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 7/06/11 Sceau:



Date: Mardi, 2011-04-19 07:36:27

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 32790

Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

33.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total: 0.0144 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

34.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7096-1

35.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total: 0.450 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31015-1

36.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run: 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 8-6-11 Sceau:



37.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Spacer N° D2213 N° de Lot: 1-30683-1

38.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 9/6/11 Sceau:



39.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-28961-2

40.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-29932-3

41.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Préparer la pièce selon IG 0008.

Quantité: 1 Date: 13/6/11 Sceau:



Date: Mardi, 2011-04-19 07:36:28
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 32790

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:




Séq.: Machine ou Opération: Description :

42.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 14-6-11 Sceau:  # de fiche de mélange: N/A

43.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-31178-3

44.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG 0008.

Date: 15/06/11 Sceau: 

45.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-28961-2

46.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase


Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-29932-3

47.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 16 juin 11 Sceau:  # de fiche de mélange: N/A

48.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 16 JUIN 2011 Sceau:  Initiales: GA

Date: Mardi, 2011-04-19 07:36:28
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 32790

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

49.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 0057.

Date:

16 juin 11

Sceau:

